

Work Order ID 54689

December 16, 2009 10:49:52 AM

Page 1

Item ID: D3891-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Gasket

Start Date: 12/16/09 Start Qty: 1.00

Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: PL

Date: 09-12-16

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3891

A

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3891

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B 9-12-16

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 9-12-16

Work Order ID 54689

December 16, 2009 10:49:52 AM



Page 2

Item ID: D3891-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 802/12/17

(40)

130

Identify as per dwg & Stock Location: QA

0.00



Packaging

Memo

0.00

Packaging

809/12/17

(11)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10.01.05

P 0912-18
①

Picklist Print

December 16, 2009 10:49:51 AM

Page 1

Work Order ID: 54689

Parent Item: D3891-3

Parent Item Name: Gasket

Comments:

Start Date: 12/16/09

Required Date: 12/18/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M4111NS.125

Purchased

No

100

sf

322.3414

3.8989



12-12-09

4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

112335

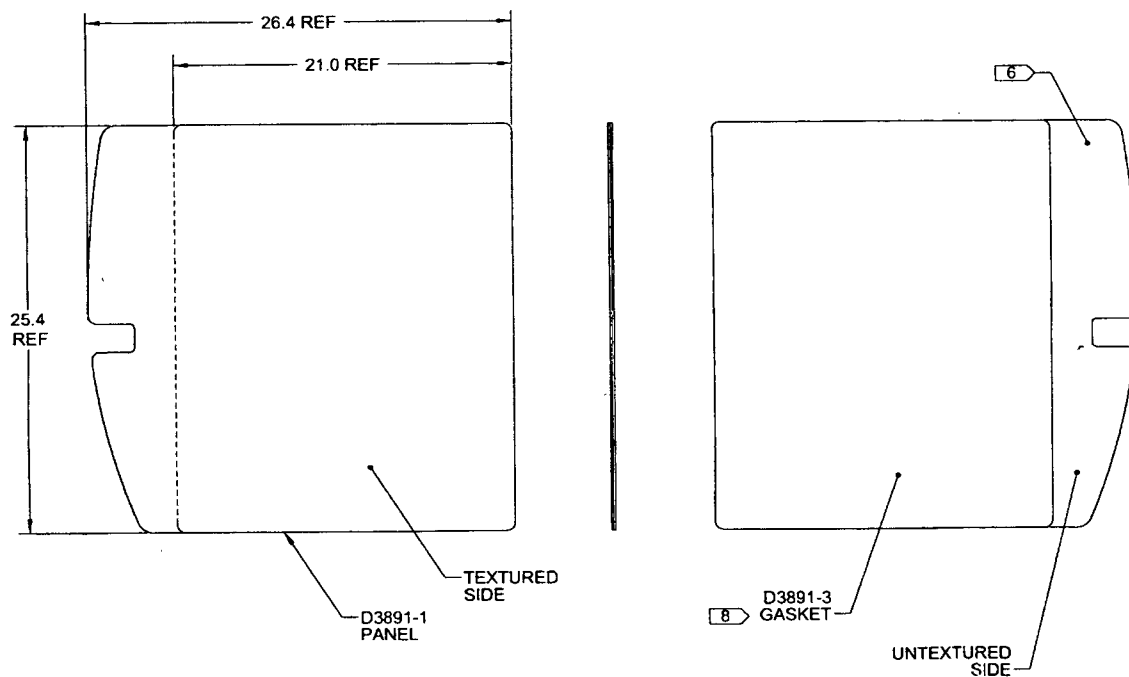
322.3414

322.3414

112335

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE

**D3891-041 PANEL, FWD LH**

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
 - 7) WEIGHT: 3.67 lbs
 - 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54689
BP 09-12-16

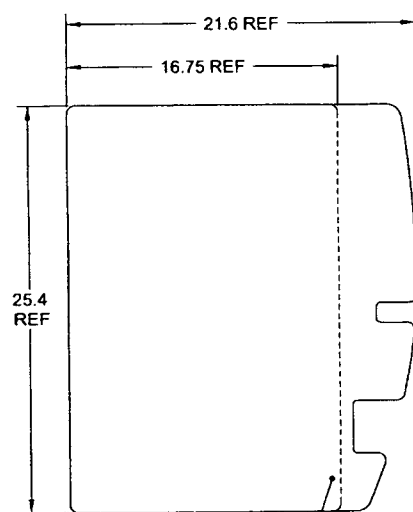
RELEASED
C9/06/16 NV

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	JP		
DRAWN	JP		
CHECKED	AB		
MFG. APPR.	AM		
APPROVED	AM		
DE APPR.	#		
DATE	09.05.01		

DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN	JP		
CHECKED	AB	DRAWING NO.	SHEET 1 OF 6
MFG. APPR.	AM	D3891	
APPROVED	AM	TITLE	SCALE
DE APPR.	#	PANEL, FWD	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED IN THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

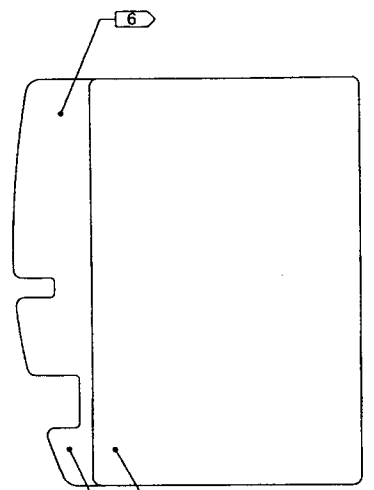
PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-042	PANEL, FWD RH
2	1	D3891-2	PANEL
3	1	D3891-4	GASKET
4	A/R	3M 1300	ADHESIVE

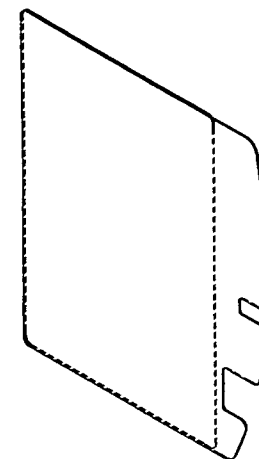


D3891-2 PANEL

TEXTURED SIDE

D3891-042 PANEL, FWD RH

D3891-4 GASKET 8

UNTEXTURED
SIDE

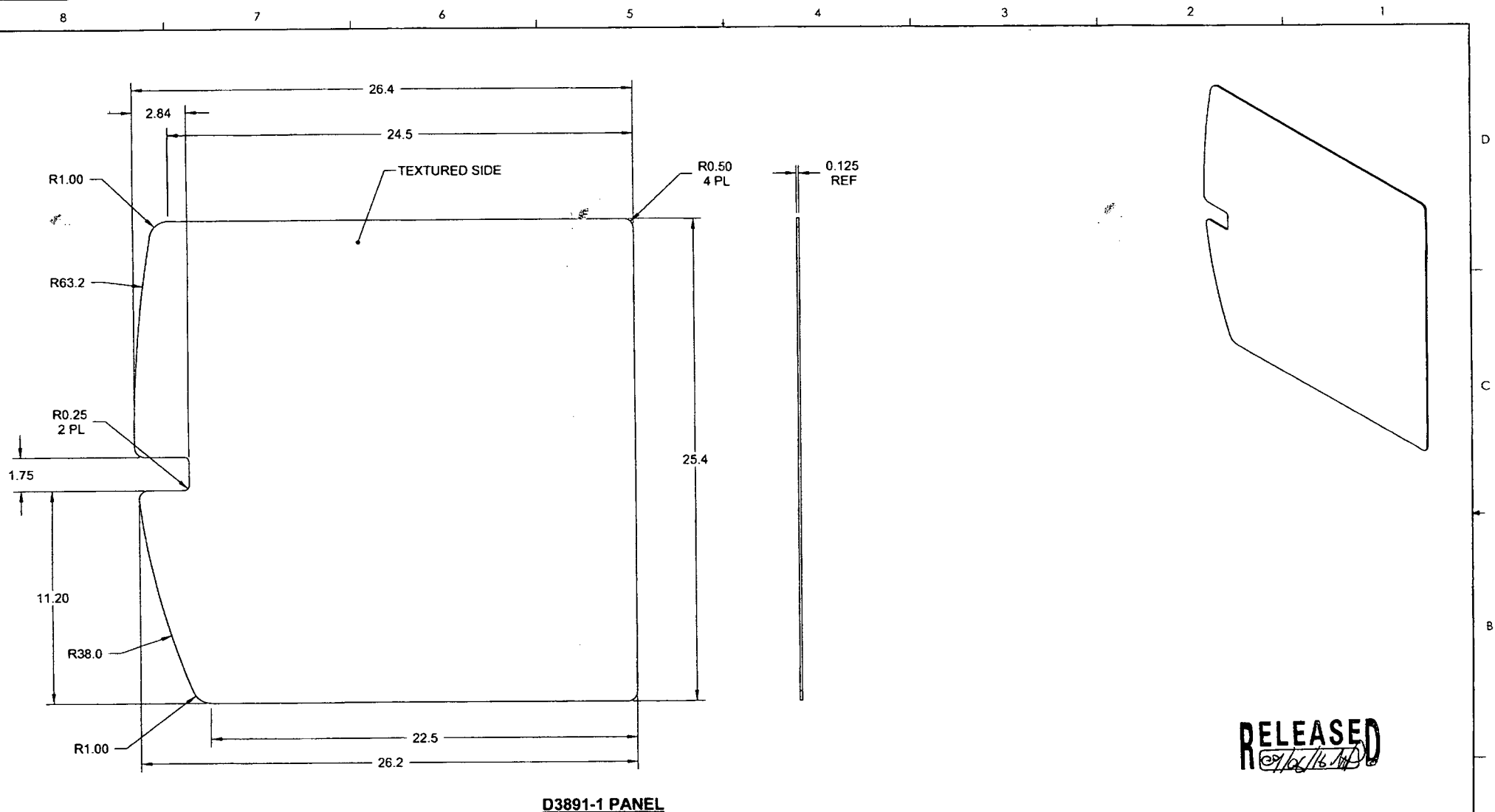
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.93 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

RELEASED
09/05/01

DESIGN	gp	DART AEROSPACE LTD	
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CHECKED	RL	DRAWING NO.	REV. A
MFG. APPR.	SL	D3891	SHEET 2 OF 6
APPROVED	SL	TITLE	SCALE
DE APPR.	SL	PANEL, FWD	NTS
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W10 54689



NOTES:

1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

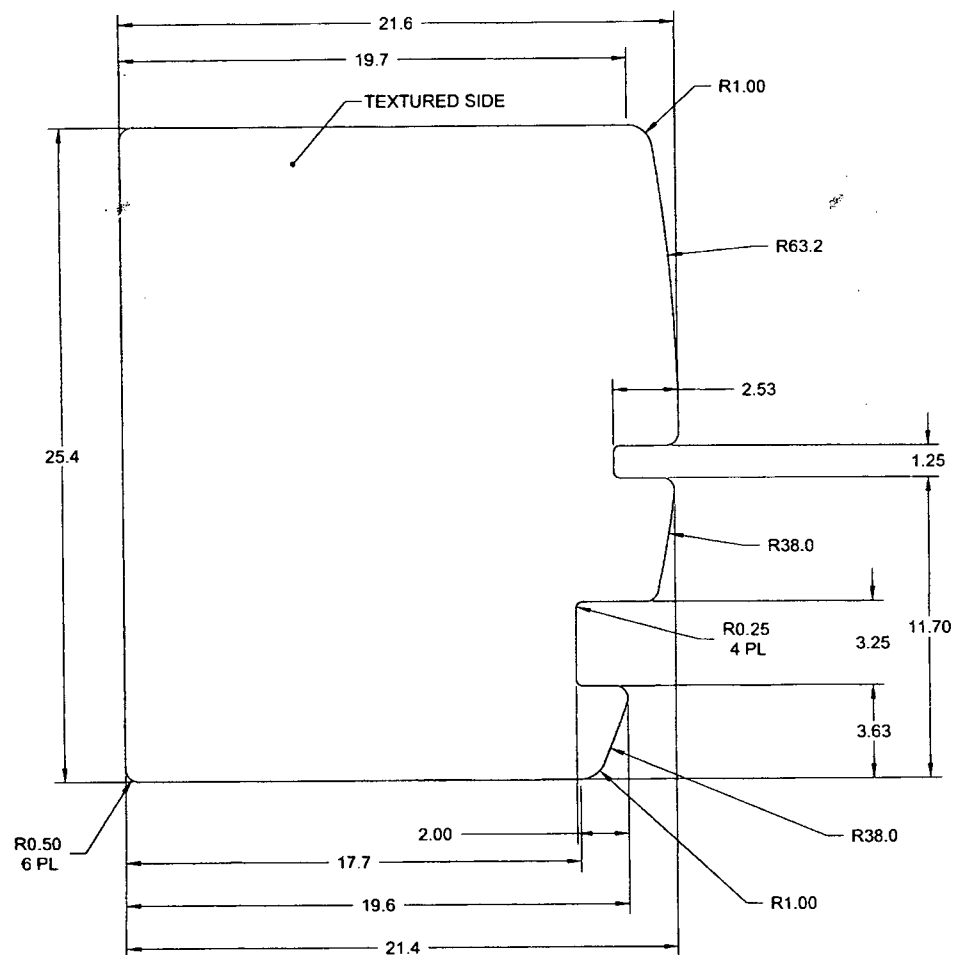
6) IDENTIFICATION: NONE

7) WEIGHT: 3.46 lbs

RELEASED
09/06/16

W10 54689

DESIGN	02	DART AEROSPACE LTD	
DRAWN	02	HAWKESBURY, ONTARIO, CANADA	
CHECKED	02	DRAWING NO.	REV. A
MFG. APPR.	02	D3891	SHEET 3 OF 6
APPROVED	02	TITLE	SCALE
DE APPR.	02	PANEL, FWD	NTS
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D3891-2 PANEL

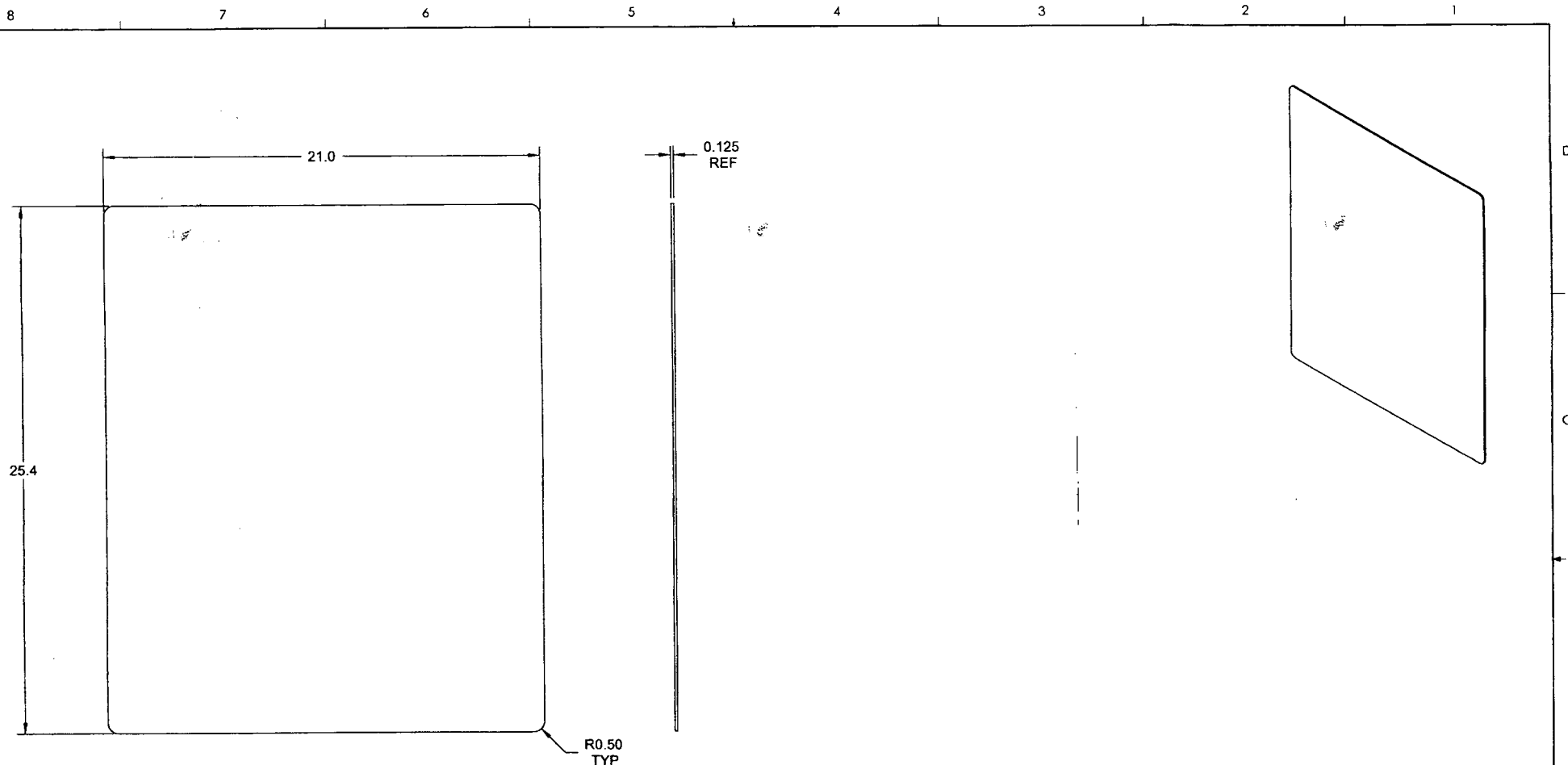
NOTES:

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXX.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.77 lbs

RELEASED
09/05/01

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DRAWN	gp		
CHECKED	As	DRAWING NO.	REV. A
MFG. APPR.	MP	D3891	SHEET 4 OF 6
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D3891-3 GASKET

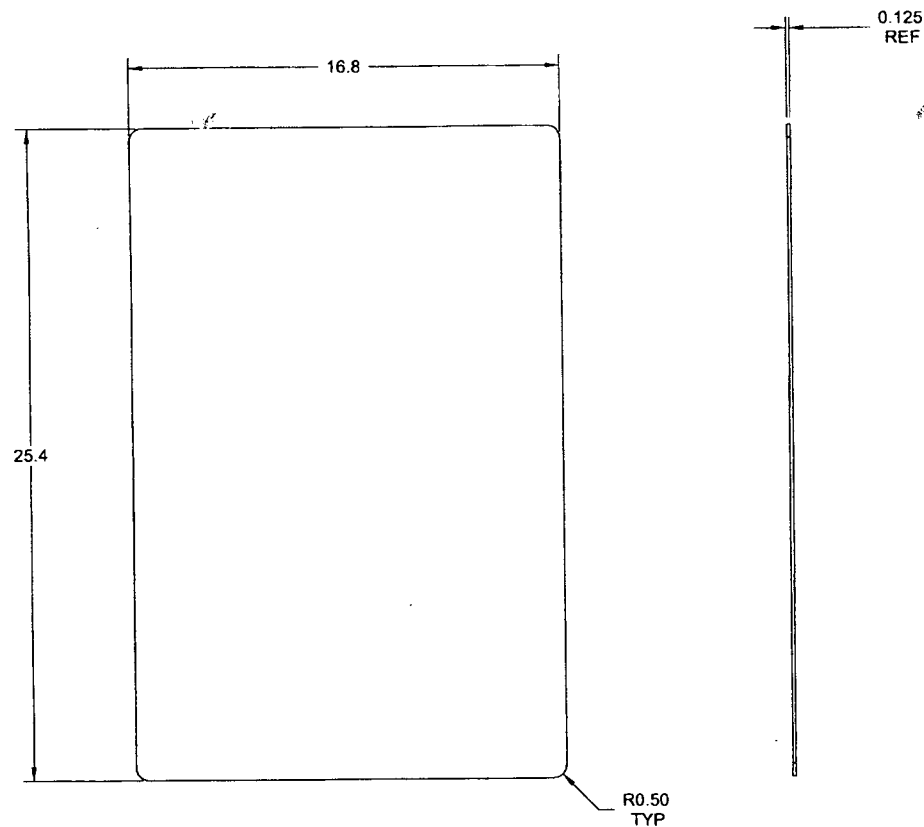
NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.21 lbs

RELEASED
09/05/16

W/O 54689

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D3891	SHEET 5 OF 6
APPROVED	92	TITLE	SCALE
DE APPR.	92	PANEL, FWD	NTS
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D3891-4 GASKET

RELEASED
09/08/16-10

W/0 54689

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs

DESIGN	40	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	40		
CHECKED	PA	DRAWING NO.	REV. A
MFG. APPR.	W/0	D3891	SHEET 6 OF 6
APPROVED	W/0	TITLE	SCALE
DE APPR.	W/0	PANEL, FWD	NTS
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